



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3315
Job Sheet 194918



DAS
21
9-89

Part No: 646.3315

Job Qty: 20 pcs *30*

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/10/19

Job Tracking No:

Due Date: 6/24/19 *or sooner*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	6/24/19	6/24/19	0.00	0.80	Bandsaw - 1		<i>aml 19/06/17</i>
110	HAAS 4 Axis - B4B	20 pcs	6/24/19	6/24/19	0.51	14.59	HAAS - 1 - B4B		<i>aml 19/06/17</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs	6/24/19	6/24/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Outsource - 1 - Heat Treat	20 pcs	6/24/19	6/24/19			MEI001-VC	15	<i>aml 19/06/17</i> <i>2019-06-18</i>



Container No: S190730



Part: 646.3315

Job No: 194918

Serial No/Batch: S190730

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/17/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

5/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 Packaging 2-1 - Receive - 20
B4B pcs

6/24/19 0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 -
B4BPackaging 2 - 11 -
B4BPackaging 2 - 12 -
B4BPackaging 2 - 13 -
B4BPackaging 2 - 14 -
B4BPackaging 2 - 15 -
B4BPackaging 2 - 16 -
B4BPackaging 2 - 17 -
B4BPackaging 2 - 18 -
B4BPackaging 2 - 19 -
B4BPackaging 2 - 20 -
B4BPackaging 2 - 21 -
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B4BPackaging 2 - 26 -
B4BPackaging 2 - 27 -
B4BPackaging 2 - 28 -
B4BPackaging 2 - 29 -
B4BPackaging 2 - 30 -
B4BPackaging 2 - 31 -
B4BPackaging 2 - 32 -
B4BPackaging 2 - 33 -
B4BPackaging 2 - 34 -
B4BPackaging 2 - 35 -
B4BPackaging 2 - 36 -
B4B

DP JUL 03 2019

155 QC 6

20

6/24/19 0.00 0.00

QC 6 - 9

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	pcs				QC 6 - 68		
					QC 6 - 61		
					QC 6 - 40		
160	Spray Paint - 2 - B4B	20	6/24/19	0.00 0.68	Spray Paint - 1 - B4B		
	pcs				Spray Paint - 2 - B4B		
					Spray Paint - 3 - B4B		
					Spray Paint - 4 - B4B		
170	QC 14	20	6/24/19	0.00 0.00	QC 14 - 15		
	pcs				QC 14 - 2		
					QC 14 - 34		
					QC 14 - 41		
					QC 14 - 51		
					QC 14 - 58		
					QC 14 - 59		
					QC 14 - 9		
					QC 14 - 68		
					QC 14 - 40		
					QC 14 - 19		
					QC 14 - 43		
					QC 14 - 24		
180	Packaging 3-1 - Stock - B4B	20	6/24/19	0.00 0.00	Packaging 3 - 1 - B4B		
	pcs				Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B	PC	CCK 102
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 -		

				B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	6/24/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-88
				QC 21 - SA - 53	JUL 05 2019

Part Op 100 - (Bandsaw) Cut Blank at 2.600"

Descriptions: 110 - HAAS1-1 (HAAS CNC Vertical Machine) 1-Machine per folio FB147

130 - (QC8- Inspect parts - second check)

140 - HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

160 - (Spray Paint / NDT Room) PRIME AS PER DWG, SEE NOTE #4

170 - (QC14- Inspect Spray Paint)

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	4.3400 ft (.217 ea)	100-Bandsaw - 1	5172910

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	4	67	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.325inches $\pm$ 0.005	0.330 0.320		
2	Blade	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	
3	Blade	0.375inches $\pm$ 0.005	0.380 0.370		
4	Blade	2.460inches $\pm$ 0.010	2.470 2.450		
5	Blade	1.817inches $\pm$ 0.005	1.822 1.812		
6	Blade	1.192inches $\pm$ 0.002	1.194 1.190		
7	Blade	0.250inches $\pm$ 0.002	0.252 0.248		
8	Blade	0.256inches $\pm$ 0.002	0.258 0.254		
9	Blade	0.290inches $\pm$ 0.002	0.292 0.288		
10	Blade	0.940inches $\pm$ 0.010	0.950 0.930		
11	Blade	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
12	Blade	55.600Degrees $\pm$ 0.500	56.100 55.100	Angle	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043766



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043766

PO Date: 6/18/19

Due Date: 6/24/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ***RUSH***

E-MAILED
2019-06-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194918	646.3315	Blade : Various STC's HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	6/24/19	30 pcs	0 pcs	30 pcs	\$9.16666/pcs	\$275.00

X30

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Grand Total: \$275.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/19/19 8:12 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

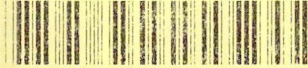
BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
337444	1	138321

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
HB043766		A2	2019/6/18	client

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight
30	646.3315			5,
	(30) 646.3315			
	JOB 194918			

1 BOITE DE CARTON

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 30

POIDS EXPÉDIÉ / Weight Shipped : 5,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

JUL 03 2019

DART AEROSPACE LTD.

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 30

POIDS EXPÉDIÉ / Weight Shipped : 5,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337444	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043766	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	6 (908)	59 - 61 HRC	

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9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
30	5	646.3315 (30) 646.3315 JOB 194918 1 BOITE DE CARTON

COMMENTAIRES / comments

VAC HARDEN 1750°F - 1:00 HRE
DOUBLE TEMPER 400°F - 2:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous

METCOR INC.

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Certificat de Conformité Détaillé

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BON DE TRAVAIL order	CHARGEMENT load
337444	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

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APPROUVÉ par / Approved by:

DATE: 2019-06-28

Lucie Desmarais
QA Technician



DA
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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

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Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337444	1

CLIENT / customer 215

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HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043766	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

DAS
40
9-89

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	6 (908)	59 - 61 HRC

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30	5	646.3315 (30) 646.3315 JOB 194918 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-06-28

Pierre Piché
Chief Inspector



APPROUVÉ